	er ID 59521 2010 3:06:03 PM					Page				
Item ID: Revision ID:	D4055-041		Accept					Setup St	art	
Item Name:	Fuel Tank Assembly	,						S	top	
Start Date: Required Date: Reference:	6/4/2010 Start Qty: 1.00 6/10/2010 Regid Qty: 1.00			Cust Item I Customer:	D:				1100	
Approvals:	Process Plan:	Date/OG/	Tooling:	D		_	l	Run St	art	
rippi ovuis.	QC:	Date:	SPC (Y/N):	**	nte:			Si		
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Rejec Numb	-
Draw Nbr	Revision Nbr									
D4055	Α		\						,	1
100 Large Fab Large Fab	Memo 1- weld I as per dv 2- Weld	Aluminum rod Batch:	4055-1 Top	e onto D4055-11) We	el (0	

3- Weld D4000-043 and D4000-045 on tank as per dwg.4- Instal D4000-9 grommets as per dwg, Weld D4055-3 aft end as per dwg, locate D4000-1 fitting using locating jig DTXXXX and weld as per dwg

2- weld D3999-041/-043 doubler followed by D3999-9 inside tank, ensure

doubler and angle holes line-up for D4000-047

5-Weld D4055-7 fwd end

W/O:	•		WO	RK ORDER CHANG	ES	. ,			 ,
DATE	STEP	PRO	OCEDURE CHAI		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								•	
Part No	:	PAR #:	Fault Cateo	jory:	NCR: Yes	No DQ	A :	Date:	
	Reso	olution:						Date: _	
NCR:		1	WORK ORDE	ER NON-CONFORMA	NCE (NC	₹)			
DATE	STEP Description of NC			on B	Verific	cation	Approval	Approval	
DATE	0,2,	Section A	Initial Chief Eng	Action Description Chief Eng	Sign of Date		ion C	Chief Eng	QC Inspector

Work Order ID 59521

Friday, June 04, 2010 3:06:03 PM



Page 2

Item ID:

D4055-041

Accept

Setup Start

Stop



Revision ID:

Item Name:

Fuel Tank Assembly

Start Date:

6/4/2010

Start Qty: 1.00

Required Date: 6/10/2010

Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:		1 (30) (1) (1)								
Approvals:	Process Plan:	Date:	Tooling:	D:	ate:		R	un Sta		
	QC:	Date:	_ SPC (Y/N): _	D	ate:			Sto	р	
Sequence ID/ Work Center II	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
	QC9- Inspect visu	al per QSI004- Fusion Welds	0.00							-
QC Quality Control	Mem	0	0.00							
121	Weld per dwg A/	R Aluminum rod Batch:	0.00							
Large Fab Large Fab	Mem 1-We	o d top D4055-1	0.00							
122	QC9- Inspect visu	al per QS1004- Fusion Welds	0.00							

Memo

0.00

Quality Control

Dart Aerospac	ce	Ltd
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W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Cate	egory:	_ NCR: Yes	No DQA :		Date:	
		esolution:	Disposition	on:	_ QA: N/C Clo	osed:		Date: _	
NCR:		,	WORK ORD	ER NON-CONFORMA	NCE (NCR)		2-00	
DATE	STEP	Description of NC		Corrective Action Secti		Verifica	ition	Approval	Approval
DAIL	JILI	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Chief Eng	QC Inspector
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Work Order ID 59521

Friday, June 04, 2010 3:06:03 PM



Page 3

Item ID:

D4055-041

Accept

Se

Setup Start

Stop



Revision ID:

Item Name:

Required Date: 6/10/2010

Fuel Tank Assembly

Start Date:

6/4/2010

Start Qty: 1.00

Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:										
Approvals:	Process Plan:QC:	Date:	Tooling:		ate:		R	un Sta Sto		
	QC	_ Date:	_ SPC (Y/N): _	D;	ate:					
Sequence ID/ Work Center II	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
123	QC5- Inspect part comp	leteness to step on W/O	0.00							*
QC Quality Control	Memo		0.00					***************************************		
130	Chemical Conversion C	oat per QSI005 4.1	0.00							
HandFinish Hand Finishing	Мето		0.00							
140	QC3- Inspect Part Finisl	1	0.00							

Quality Control

Memo

0.00

	•								
W/O:			WC	RK ORDER CHANG	ES				
DATE	STEP	PR	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			·						
				A					
Part No	:	PAR #:	Fault Cate	jory:	_ NCR: Yes	No DQA	\:	 Date:	
		olution:							
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCF	R)			
DATE	STEP	STED Description of NC		Corrective Action Section			ation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Section		Chief Eng	QC Inspector
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								:	
									

Work Order ID 59521

Friday, June 04, 2010 3:06:03 PM



Page 4

Item ID:

D4055-041

Accept



Setup Start



Revision ID:

Item Name: Fuel Tank Assembly

Start Date: Required Date: 6/10/2010

6/4/2010 Start Qty: 1.00

Req'd Qty: 1.00



Cust Item ID: Customer:

Tool ID

Reference:

Approvals:	
------------	--

Process Plan: _____

Date:

Tooling:

Date:

Run

Reject

Qty

Accept

Qty

Start

Stop



QC:

Date:

SPC (Y/N):

Date:

Tool # Plan

Code

Stop



Number Stamp

Insp.

Reject

Sequence ID/ **Work Center ID**

150

Quality Control

Operation

Description

Memo

Pressure test as per dwg

Set Up/ **Run Hours**

0.00

0.00

160

HandFinish

Memo

0.00

0.00

Hand Finishing

170

Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Memo

Mask prior to powdercoat

Start Time:

Oven Temperature:

Finish Time:

0.00

W/O:			WO	RK ORDER CHANC	GES					
DATE	STEP	PRO	PROCEDURE CHANGE			У	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:								
		olution:							Date:	
NCR:			WORK ORDE	R NON-CONFORM	ANCE (I	NCR)				
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Sec Action Description Chief Eng		ign & Date	Verification Section C		Approval Chief Eng	Approval QC Inspector
						· ···)		

Work Order ID 59521

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Page 5

Item ID:

D4055-041

Accept

Accept

Qty

Setup Start

Stop



Revision ID:

Item Name:

Fuel Tank Assembly

Start Date:

Reference:

6/4/2010

Start Qty: 1.00

Required Date: 6/10/2010

Req'd Qty: 1.00



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:_____

Tooling:

Date:

Code

Start

Stop

Reject



Number Stamp

Insp.

Reject

Qty

Run

QC: Date:_____ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool # Plan **Tool ID** Description **Run Hours**

Work Center ID

180

Quality Control

Memo

QC3- Inspect Part Finish

0.00

0.00

190

Small Fab

Small Fab

Memo

0.00

0.00

Assemble as per dwg

QC5- Inspect part completeness to step on W/O

200

Quality Control

0.00

Memo

0.00

	-									
W/O:			WO	RK ORDER CHANG	GES				····	
DATE	STEP	PRO	OCEDURE CHAI	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cated	iorv:	NCF	t: Yes	No DQ	Δ.	Date:	
		olution:								
NCR:				R NON-CONFORM						
DATE	STEP Description of NC					Section B			Approval	Approval
	J.L.	Section A	Initial Action Descrip Chief Eng Chief Eng		ption Sign & Date				Chief Eng	QC Inspector
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Work Order ID 59521

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Page 6

Item ID:

D4055-041

Accept

Setup Start

Stop



Revision ID:

Item Name:

Fuel Tank Assembly

Start Date:

6/4/2010

Start Qty: 1.00

Required Date: 6/10/2010

Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference: Start Run Approvals: Process Plan: _____ Date: ____ Tooling: Date: Stop Date: _____ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept Reject Insp. Work Center ID Description **Run Hours** Qty Code Qty Number Stamp 210 0.00 SprayPaint 0.00 Memo Spray Painting Seal inside of tank using 220 QC5- Inspect part completeness to step on W/O 0.00 QC 0.00 Memo Quality Control

230

Packaging

Identify as per dwg & Stock Location:

Memo

0.00

0.00

Packaging

		- 								
W/O:			W	ORK ORDER CHAN	GES				· · · · · · · · · · · · · · · · · · ·	
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	C	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	egory:	NCR: Ye	s No	DQ,	A :	Date:	
	Res	olution:	Disposition	on:	QA: N/C	Close	ed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORM	IANCE (N	CR)				
DATE	STEP Description of NC		1	ction B	Verifica			Approval	Approval	
		Section A	Initial Chief Eng	Action Description Chief Eng	Da Da		Secti	on C	Chief Eng	QC Inspector
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Work Order ID 59521

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Item ID:

D4055-041

Revision ID:

Item Name:

Fuel Tank Assembly

Start Date: Required Date: 6/10/2010

6/4/2010

Start Qty: 1.00

Operation

Description

Req'd Qty: 1.00



Accept



Setup Start

Stop

Cust Item ID: Customer:

Tool ID

Reference:

Approvals:

QC:

Process Plan:

Date:

Date:

Tooling:

SPC (Y/N):

Set Up/

Run Hours

Date:

Tool # Plan

Code

Date:

Reject

Qty

Stop

Sequence ID/ Work Center ID

240

QC21- Final Inspection - Work Order Release

Run

Accept

Qty

Start

Memo

0.00

0.00

Reject

Insp. Number Stamp

Quality Control

	•								
W/O:			WC	RK ORDER CHANC	GES				
DATE	STEP	PR	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
-									
Part No	:	PAR #:	#: Fault Category: NCR: Yes No DQA: Date: Disposition: QA: N/C Closed: Date: WORK ORDER NON-CONFORMANCE (NCR)						
	Res	WORK ORDER N Description of NC Section A Disposition: Correct Initial		1:	QA: N/C	Closed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORM	ANCE (N	CR)			
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	SIEP	Section A				n& s			QC Inspector
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Friday, June 04, 2010 3:06:08 PM

Work Order ID: 59521 Parent Item: D4055-041 Parent Item Name: Fuel Tank Assembly Start Date: 6/4/2010 Required Date: 6/10/2010 Comments: IPP rev A 10.03.08 new issue prelim EC verified by:DD IPP Rev:B Start Qty: 1.00 Required Qty: 1.00 10.05.17 ECN10-562 DD verf:EC Component Item ID/ Replacement Mfg/ Bin Primary Last Route Unit of Qty on Qty per Kit Total Date Qty Status Item Name Item ID Purch Item Location Location Seq ID Measure Hand Issued Issued Otv AN3H5A Purchased No Each 0.0000 5 Bolt D4057-1 Manufactured No Each 0.0000 3 Retaining Ring NAS1149D0363J Purchased No Each 438.0000 5 Washer Location Loc Qty Loc Code ST298 438 113288 2 114292 436 D3999-1 Manufactured No Each 0.0000 Baffle D3997-5 Manufactured No Each 10.0000 2 Placard Location Loc Qty Loc Code ST108 10 55402 10 D3997-11 Manufactured No Each 10.0000 Placard Location Loc Oty Loc Code ST108 10 55407 10

W/O:			WC	RK ORDER CHANG	GES					
DATE	STEP	PRO	OCEDURE CHAI	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	gory:	NCF	R: Yes	No DQ /	A:	Date:	
		solution:								
NCR:			WORK ORDI	R NON-CONFORM	ANCE	(NCR)			
DATE	STEP	Description of NC			tion B	Ciam 9	Verific		Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti	on C	Chief Eng	QC Inspector
					!					

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Work Order ID: 59521

Parent Item:

D4055-041

Parent Item Name:

Fuel Tank Assembly

Comments:

IPP rev A 10.03.08 new issue prelim EC verified by:DD



IPP Rev:B

Start Date: 6/4/2010

Required Date: 6/10/2010

Start Qty: 1.00

Required Qty: 1.00

10	0.05.17 ECN10-5	62 DD verf:EC							20,7 1.00			va Qiji 1.0	•
Component Item ID/ Item Name D3997-17 Placard	Replacement Item ID	Mfg/ Purch Manufactured	Bin Item No	Primary Location	Last Location	Route Seq ID	Unit of Measure Each	Qty on Hand 10.0000	Qty per Kit	Total Otv 1	Qty Issued	Date Issued	Status
				Location ST108	55410	Loc	<u>Otv</u> 10 10	Loc Code	_				
D3997-29		Manufactured	No				Each	10.0000	1	1	_		
				Location ST108	55416	<u>Loc (</u>	Oty 10 10	Loc Code	_		_		
D3997-43 Placard		Manufactured	No				Each	10.0000	1	1	_	··.	
				Location ST108	55422	<u>Loc (</u>	<u>Oty</u> 10 10	Loc Code			_		
D3999-7		Manufactured	No				Each	7.0000	1	1			
				<u>Location</u> ENG	55645	Loc	Oty 7 7	Loc Code			- -		

W/O:			WO	RK ORDER CHAN	GES	· · · · · · · · · · · · · · · · · · ·				
DATE	STEP	PRO	OCEDURE CHAI	IGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Categ	jory:	NCR	: Yes	No DQ	A :	_ Date: _	
	Res	olution:	Disposition	l:	QA:	N/C CI	sed:		Date:	
NCR:			WORK ORDE	R NON-CONFORM	IANCE	(NCR)			
DATE	STEP	Description of NC	· · · · · · · · · · · · · · · · · · ·		ction B	0:	Verific	ation	Approval	Approval
DATE		Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti	on C	Chief Eng	QC Inspector
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Picklist Print

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Page 3

Work Order ID: 59521

Parent Item:

D4055-041

Parent Item Name:

Fuel Tank Assembly

Comments:

IPP rev A 10.03.08 new issue prelim EC verified by:DD 10.05.17 ECN10-562 DD verf EC

Start Date: 6/4/2010

Required Date: 6/10/2010

Start Qty: 1.00

Required Qty: 1.00

	0.05.17 ECN10-5	62 DD verf:EC										- •	
Component Item ID/ Item Name D3999-9 Angle	Replacement Item ID	Mfg/ Purch Manufactured	Bin Item No	Primary Location	Last Location	Route Seq ID	Unit of Measure Each	Qty on Hand 5.0000	Qty per Kit	Total Otv 1	Qty Issued	Date Issued	Status
				<u>Location</u> ENG	55646	<u>Loc (</u>	<u>Dty</u> 5 5	Loc Code	_		_		
D3999-11 		Manufactured	No				Each	5.0000	1	1			
				<u>Location</u> ENG		Loc C	<u>Oty</u> 5	Loc Code					
D3999-041 Baffle Assembly, Aft		Manufactured	No		55863		5 Each	1.0000	1	1	_		
				<u>Location</u> ENG		Loc C	<u>)ty</u> 1	Loc Code	_				
D3999-043		Manufactured	No		55648		I Each	1.0000	I -	1	_		
,, <u>.</u>				<u>Location</u> ENG	55649	Loc Q	1 1	Loc Code			-		

IPP Rev:B

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W/O:			WO	RK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	CR:								
Part No: PAR #: Fault Category: NCR: Yes No DQA: Resolution: Disposition: QA: N/C Closed: WORK ORDER NON-CONFORMANCE (NCR) DATE STEP Description of NC Corrective Action Section B	Date:	·····							
	Res	solution:	Disposition	:	_ QA: N/C C	losed:		Date: _	
NCR:		,	WORK ORDE	ER NON-CONFORMA	ANCE (NC	R)			
	STEP					Verifi	cation	Approval	Approval
		Section A					ion C	Chief Eng	QC Inspector
			Fault Category: NCR: Yes No DQA: Disposition: QA: N/C Closed: VORK ORDER NON-CONFORMANCE (NCR) Corrective Action Section B Verifica Initial Action Description Sign & Section B Section B Verifica						

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Page 4

Work Order ID: 59521

Parent Item:

D4055-041

Parent Item Name: Fuel Tank Assembly

Comments:

IPP rev A 10.03.08 new issue prelim EC verified by:DD 10.05.17 ECN10-562 DD verf EC



IPP Rev:B

Start Date: 6/4/2010

Required Date: 6/10/2010

Start Qty: 1.00

Required Qty: 1.00

1(0.05.17 ECN10-5	62 DD verf:EC									-	- •	
Component Item ID/ Item Name D4000-1 IIIIIIIIIIIIIIIIIIIIIIIIIIIIIIIIII	Replacement Item ID	Mfg/ Purch Manufactured	Bin Item No	Primary Location	Last Location	Route Seq ID	Unit of Measure Each	Qty on Hand 3.0000	Qty per Kit	Total Otv 1	Qty Issued	Date Issued	Status
				Location		Loc C	<u>Oty</u>	Loc Code					
				ENG	550/=		3				_		
D4000-5		Manufactured	No		55867		3	3.0000	_		_		
		Manufactured	NO				Each	3.0000	1	1			
Fuel Tank Vent Fitting	{ B										· · · · · · · · · · · · · · · · · · ·		
g				Location		Loc C	Itv	Loc Code					
				ENG		<u> 1300 C</u>	3	Loc Couc					
					55869		3				-		
D4000-9		Manufactured	No				Each	0.0000	3	3	_		
Grommet													
D4000-043		Manufactured	No				Each	0.0000	1	1			
		TVIAITATACTAT CA					Luon	0.0000		1			
Drain Fitting Assembly, Fwd													· · · · · · · · · · · · · · · · · · ·
D4000-045		Manufactured	No				Each	0.0000	1	1			
Fuel Pickup Fitting Assemby													
D4000-047	II BIBII ABBI ABBI	Manufactured	No				Each	0.0000	1	1			
Fuel Pickup Fitting Assembly	/												

	•								
W/O:			WO	RK ORDER CHANC	GES				
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	No:PAR #	PAR #:	Fault Cate	jory:	NCR: Ye	s No D	QA:	Date: _	
		esolution:							
NCR:			WORK ORDE	R NON-CONFORM	ANCE (N	CR)			
NCR:	STEP	Description of NC		·	tion B	Ver	ification	Approval	Approval
DAIL	JILI	Section A	Initial Chief Eng	Action Description Chief Eng	Sig Da	1& ∣ _S ,	ection C	Chief Eng	QC Inspector
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Work Order ID: 59521

Parent Item:

D4055-041

Parent Item Name: Fuel Tank Assembly

Comments:

IPP rev A 10.03.08 new issue prelim EC verified by:DD



IPP Rev:B

Start Date: 6/4/2010

Required Date: 6/10/2010

Start Qty: 1.00

Required Qty: 1.00

1	0.05.17 ECN10-5	62 DD verf:EC	20	vermed by .D	, ni k	CV.D			start Qty. 1.00		Kequire	eu Qiy: 1.0	U
Component Item ID/ Item Name D4001-1 Fitting	Replacement Item ID	Mfg/ Purch Manufactured	Bin Item No	Primary Location	Last Location	Route Seq ID	Unit of Measure Each	Qty on Hand 1.0000	Qty per Kit	Total Otv 1	Qty Issued	Date Issued	Status
				Location	1	Loc	<u>Oty</u>	Loc Code					
				ENG	56401		1				_		
D4008-041 Fuel Filler Splash Guard Ass		Manufactured	No		30401		Each	0.0000		1			
D4008-11 Hinge Half	•	Manufactured	No				Each	0.0000	1 	1			-
D4023-1 Cap and Flange		Manufactured	No				Each	4.0000	1 	1		· · · · · · · · ·	
				Location	1	Loc	<u>Otv</u>	Loc Code					
				ENG	55943		4		_		-		
D4025-1		Manufactured	No		33943		4 Each	4.0000	1	1	_		
Fuel Quantity Sender										-			
				Location	1	Loc	<u>Oty</u>	Loc Code					
				ENG	55937		4		_				
					33931		4		_		_		

W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHA	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			·						
Part No		PAR #:							
	Re	esolution:	Disposition	on:	_ QA: N/C C	closed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NC	R)			<u> </u>
DATE	STEP	Description of NC		Corrective Action Section		Verifi	cation	Approval	Approvai
	J.L.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sect	ion C	Chief Eng	QC Inspector
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Picklist Print

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Work Order ID: 59521

Parent Item:

D4055-041

Parent Item Name: Fuel Tank Assembly

Comments:

IPP rev A 10.03.08 new issue prelim EC verified by:DD



IPP Rev:B

Start Date: 6/4/2010

Required Date: 6/10/2010

Start Qty: 1.00

Required Qty: 1.00

1	0.05.17 ECN10-5	62 DD verf:EC			2	.cv.b			start Qty. 1.00		Require	cu Qiy. 1.0	U
Component Item ID/ Item Name D4055-11 Tank Front and Bottom	Replacement Item ID	Mfg/ Purch Manufactured	Bin Item No	Primary Location	Last Location	Route Seq ID	Unit of Measure Each	Qty on Hand 2.0000	Qty per Kit	Total Otv 1	Qty Issued	Date Issued	Status
				Location	<u>1</u>	Loc	<u>Oty</u>	Loc Code					
				ENG	550/0		2				_		
D4055-9		Manufactured	No		55962		2	2 0000	. –				
Tank Back		Manufactured	140				Each	2.0000		1	·		
				<u>Location</u>	<u>1</u>	Loc (Qty	Loc Code					
				ENG			2						
					55961		2		_		_		
D4055-7 		Manufactured	No				Each	2.0000		1			
				Location	1	Loc (Qty	Loc Code					
				ENG			2						
					55960		2		_		_		
D4055-5 	III 1881	Manufactured	No				Each	2.0000	1	1			
Γank Upper Cut Out											***		
- Pro-				<u>Location</u>	<u>1</u>	Loc (Qty	Loc Code					
				WA		· · · · ·	2						
					55959		2		_		_		
									_		_		

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W/O:			WO	RK ORDER CHANG	ES			· · · · · · · · · · · · · · · · · · ·
DATE	STEP	PR	OCEDURE CHAI	IGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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		olution:						
NCR:				R NON-CONFORM				
· ·	STEP Description of NC				ion B	Verification	Approval	Approval
	J.L.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector

Picklist Print

Friday, June 04, 2010 3:06:08 PM

Page 7

Work Order ID: 59521

Parent Item:

D4055-041

Parent Item Name:

Fuel Tank Assembly

Comments:

IPP rev A 10.03.08 new issue prelim EC verified by:DD

10.05.17 ECN10-562 DD verf:EC

IPP Rev:B

Start Date: 6/4/2010

Required Date: 6/10/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name

D4055-3

Replacement Mfg/ Item ID

Purch Manufactured

Manufactured

Bin Primary Item Location No

No

Last Location

Route Seq ID Unit of Qty on Hand Measure Each 2.0000

Qty per Kit Total Otv

Qty

Issued

Date Status **Issued**

Tank Aft End

Location

ENG

55957

55963

Loc Oty

2 2

Each

Loc Code

2.0000

D4055-1

Tank Top

Location

ENG

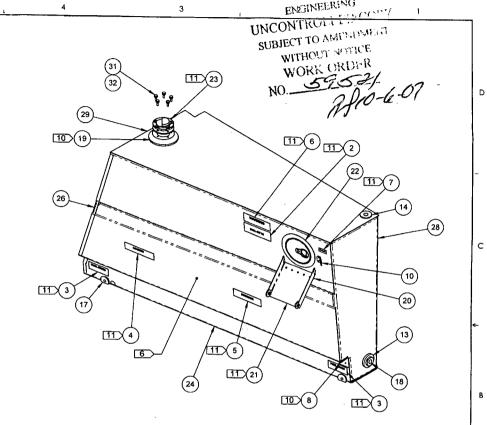
Loc Oty

2 2 Loc Code

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W/O:			WO	RK ORDER CHANG	ES						
DATE	STEP	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Resolution:			Disposition	_ QA: N/C CI	Date: _						
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NCR	1)					
DATE	CTED	Description of NC			Section B Ver		rification Approva		l Approval		
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	ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
	1	х	D4055-041	FUEL TANK ASSEMBLY
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L	2	11	D3999-1	PLACARD "FUEL JET A1"
-	3	2	D3997-5	PLACARD "AUX FUEL DRAIN"
L	4	1	D3997-11	PLACARD "LOADING"
L	5	1	D3997-17	PLACARD "STOWAGE"
L	6	1	D3997-29	PLACARD "WARNING"
L	7	1	D3997-43	PLACARD "EARTH"
L	8	1	D3999-7	CORNER
L	9	1	D3999-9	ANGLE
L	10	1	D3999-11	EARTH TAB
L	11	1	D3999-041	BAFFLE ASSEMBLY, AFT
L	12	1	D3999-043	BAFFLE ASSEMBLY, FWD
L	13	1	D4000-1	FUEL SUPPLY FITTING
	14	1	D4000-5	FUEL TANK VENT FITTING
Ĺ	15	3	D4000-9	GROMMET
	16	1	D4000-043	AFT FUEL SUMP DRAIN ASSEMBLY
E	17	1	D4000-045	FORWARD FUEL SUMP DRAIN ASSEMBLY
	18	1	D4000-047	FUEL PICK UP AND STRAINER ASSEMBLY
L	19	1	D4001-1	FITTING
L	20	1	D4008-11	TANK HINGE HALF
L	21	1	D4008-041	FUEL FILLER SPLASH GUARD ASSEMBLY
L	22	1	D4023-1	FUEL CAP
L	23	1	D4025-1	FUEL SENDER
L	24	1	D4055-11	TANK FRONT AND BOTTOM
L	25	1	D4055-9	TANK BACK
Ĺ	26	1	D4055-7	TANK FORWARD END
	27	1	D4055-5	TANK UPPER CUT OUT
Ĺ	28	1	D4055-3	TANK AFT END
L	29	1	D4055-1	TANK TOP
Ĺ	30	3	D4057-1	RETAINING RING
	31	5	AN3H5A	BOLT
	32	5	NAS1149D0363J	WASHER



D4055-041 AUX TANK

5

NOTES:
1) MATERIAL: N/A
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNILESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D350-794-041" USING D2729-1 RED DECAL
7) WEIGHT: 27.57 ibs
8) WELD PER DART QSI 004
9) CAP ALL TANK CCCESS POINTS AND PRESSURIZE TANK TO 1.5 DSI AFTER ACCEMENT.

8

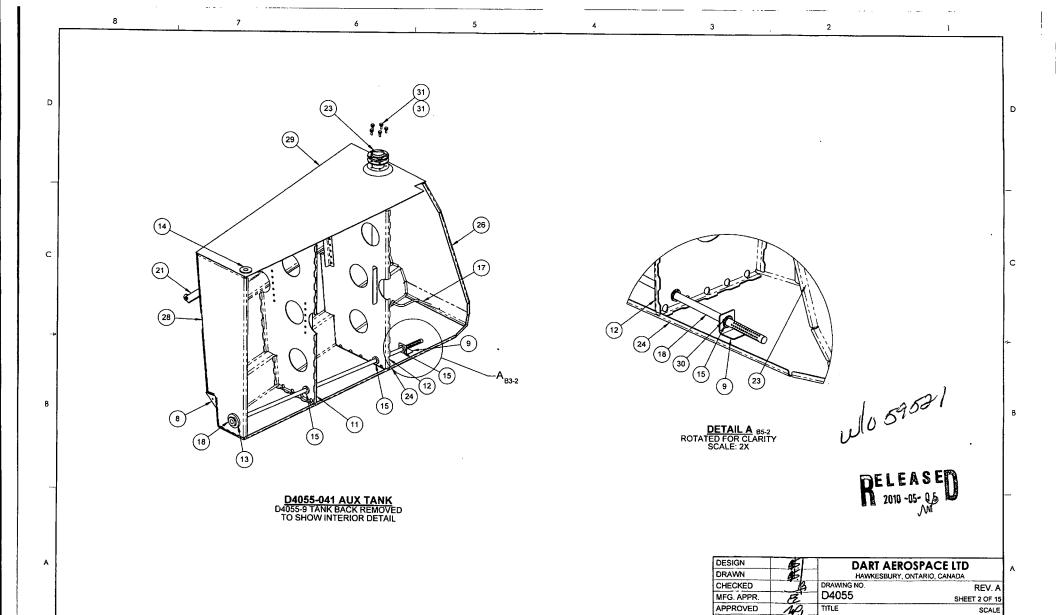
9) CAP ALL TANK ACCESS POINTS AND PRESSURIZE TANK TO 1.5 PSI AFTER ASSEMBLY. VERIFY NO LEAKS.
10) MASK PRIOR TO POWDER COAT
11) INSTALL AFTER POWDER COAT

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REV.			DESCRIPTION	BY	DATE			
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CHECK		B	DRAWING NO. D4055		REV. A			
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DE API	PR.	-44	TANK		NTS			
DATE 10.04.16			COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS COCUMENT IS PRIVATE AND CONFEDENTAL AND IS SUPPLED ON THE DIFFESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OF COPYRIGHT OF TO ANY OTHER PERSON WITHOUT WITHOUT TO BE USED FOR ANY PURPOSE OF COPYRIGHT OF THE PERSON WITHOUT WITHOUT STATEMENT OF THE PERSON WITHOUT THE PERSON WITHOUT THE PERSON WITHOUT STATEMENT OF THE PERSON WITHOUT TH					

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		Section A	Initial Chief Eng	Action Description Chief Eng	S	ign & Date	Section C	Chief Eng	QC Inspector		
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TANK

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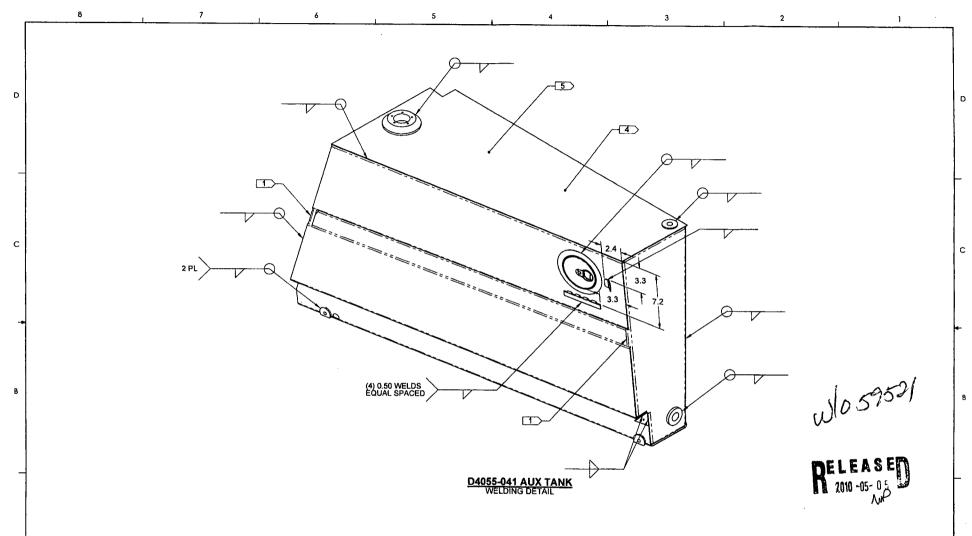
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DATE

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NOTES:
1) TRIM FLANGES AS REQUIRED TO FIT ASSEMBLY
2) FINAL CHECK BEFORE LAST PANEL INSTALLED:
- END OF FUEL PICK UP TUBE IS 0.60 OFF THE TANK FLOOR AND 1.96 FROM SIDE WALL
- FWD AND AFT DRAIN TUBES EXTEND TO CENTER OF T

- ALL SWARF REMOVED

3) AFTER FINAL ASSEMBLY, SLOSH FUEL TANK WITH MIL-S-4383 OR EQUIVALENT (PR-1005-L BUNA-N-SLOSH)
SLOSHING SEALER. ENSURE FILTERS, FITTINGS AND SENDER UNITS ARE REMOVED AFTER WELDING
4) ACCEPTABLE TO DRILL 6 (TYP) Ø0.312 HOLES IN TANK TOP TO WELD TOP TO AFT BAFFLE (1 HOLE PER BAFFLE TAB)
5) ACCEPTABLE TO DRILL 7 (TYP) Ø0.312 HOLES IN TANK TOP TO WELD TOP TO FWD BAFFLE (1 HOLE PER BAFFLE TAB)

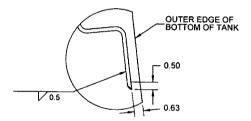
DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. A D4055 MFG. APPR. SHEET 3 OF 15 APPROVED TITLE SCALE DE APPR. **TANK** NTS

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DATE	STEP	Description of NC			Section B		Verification		Approval	Approval		
	Section A		Initial Action Descr Chief Eng Chief Eng		ption Sign & Date				Chief Eng	QC Inspector		
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7 5 WELD ALL TABS D4055-041 AUX TANK WELDING DETAIL

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DRAIN TUBE INSTALLATION - TYP
VIEWED FROM ABOVE
FWD END SHOWN, AFT END OPPOSITE

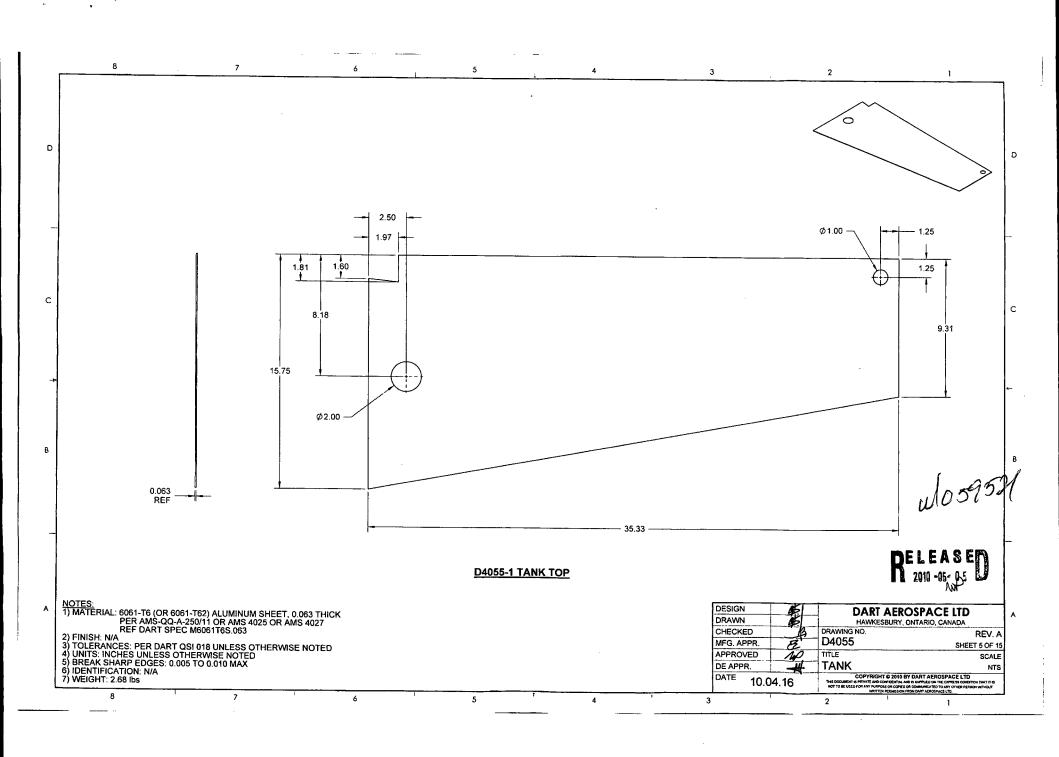
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2010-05-0

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MFG. APPR.	8	D4055	SHEET 4 OF 15
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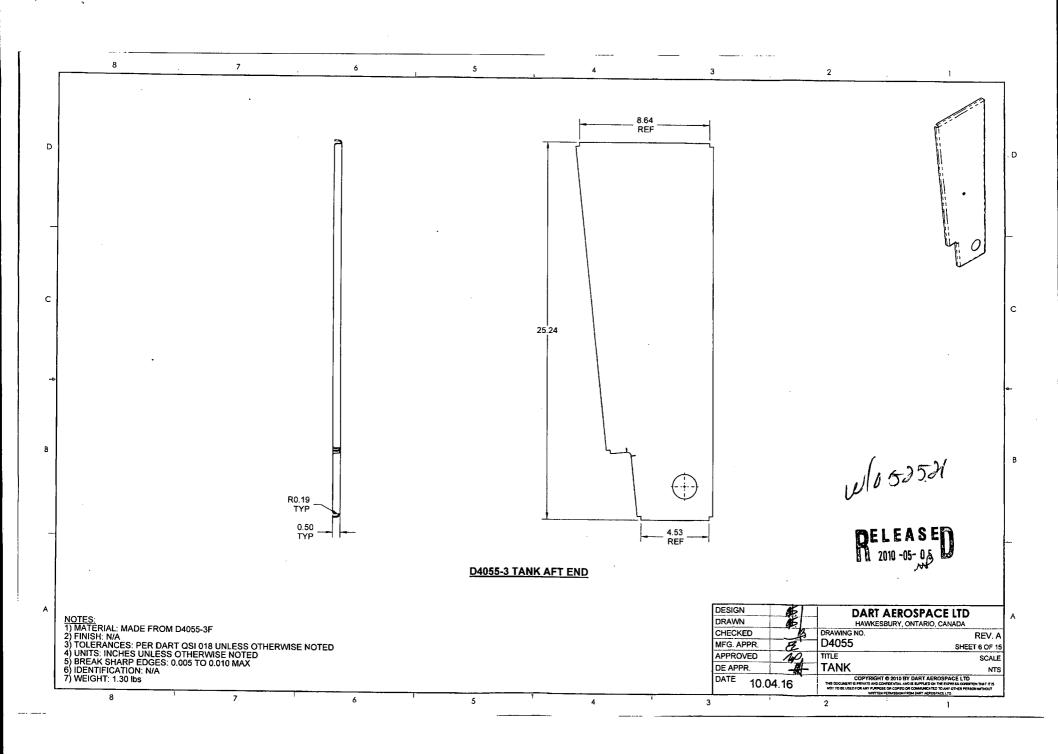
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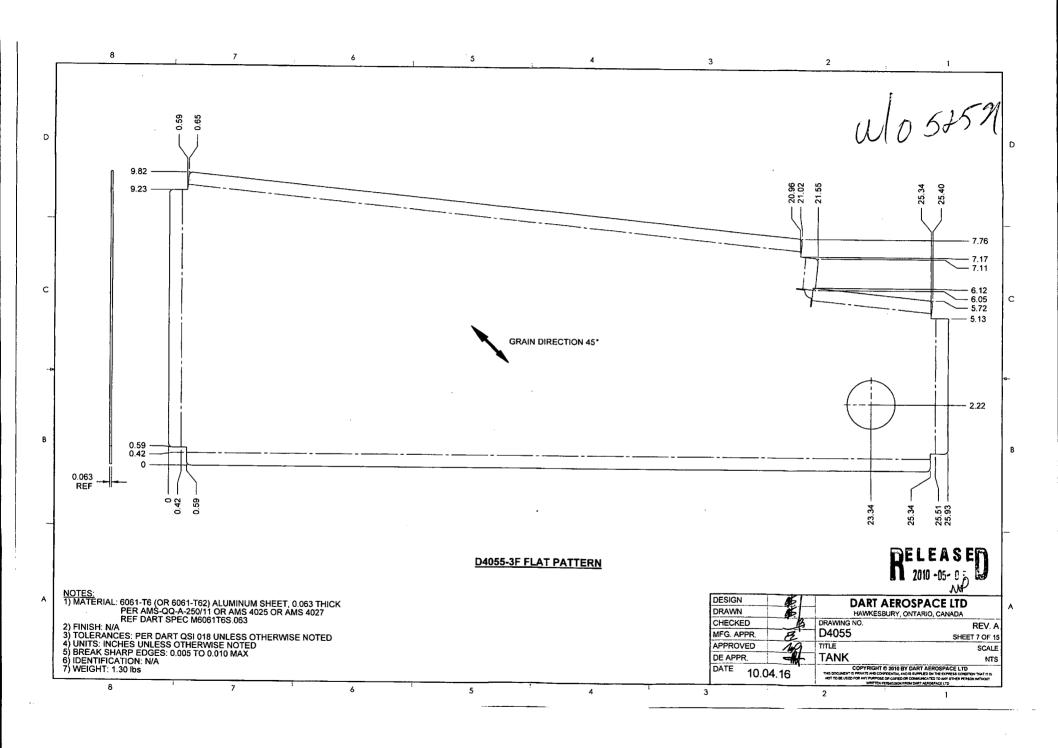


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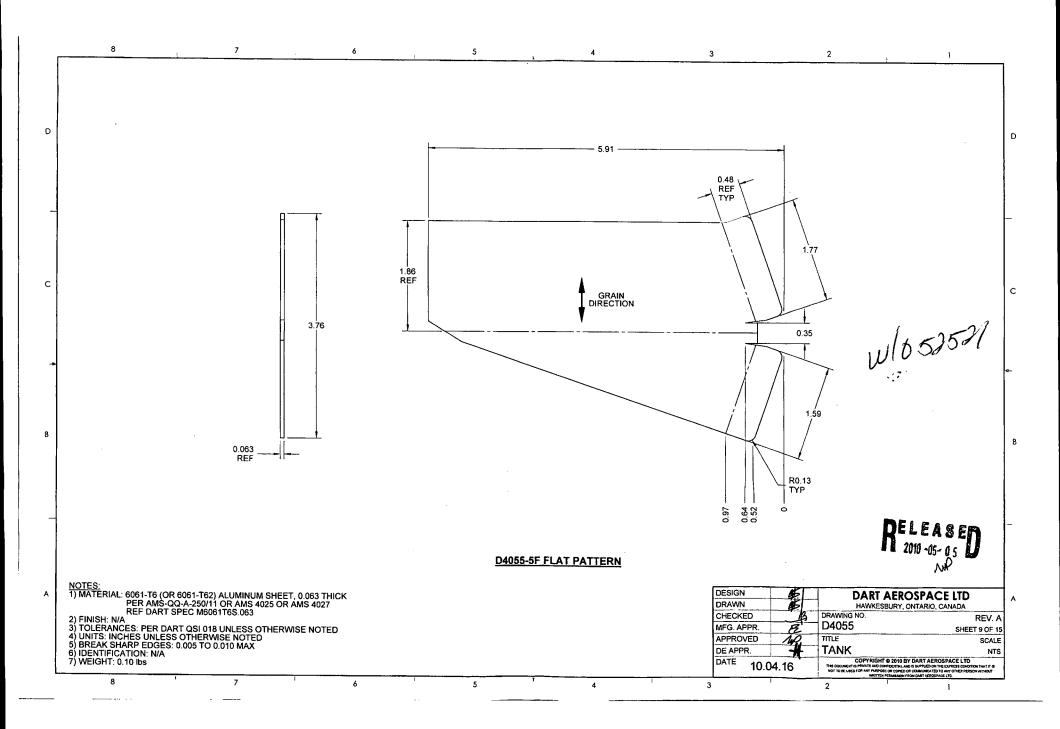


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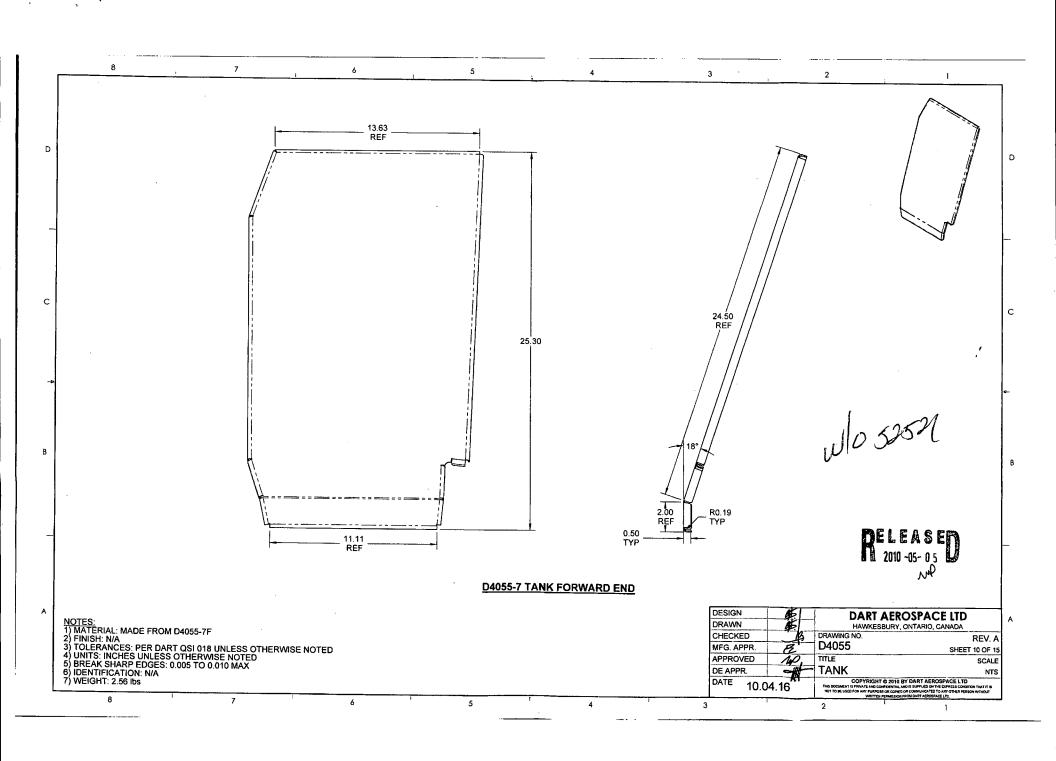
8 7 2 D REF 2.28 Wlu 32571 R0.19 TYP **D4055-5 UPPER CUT OUT** DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA NOTES:
1) MATERIAL: MADE FROM D4055-5F
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.10 lbs DRAWN DRAWING NO. CHECKED REV. A D4055 MFG. APPR. SHEET 8 OF 15 APPROVED TITLE SCALE DE APPR. **TANK** NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD

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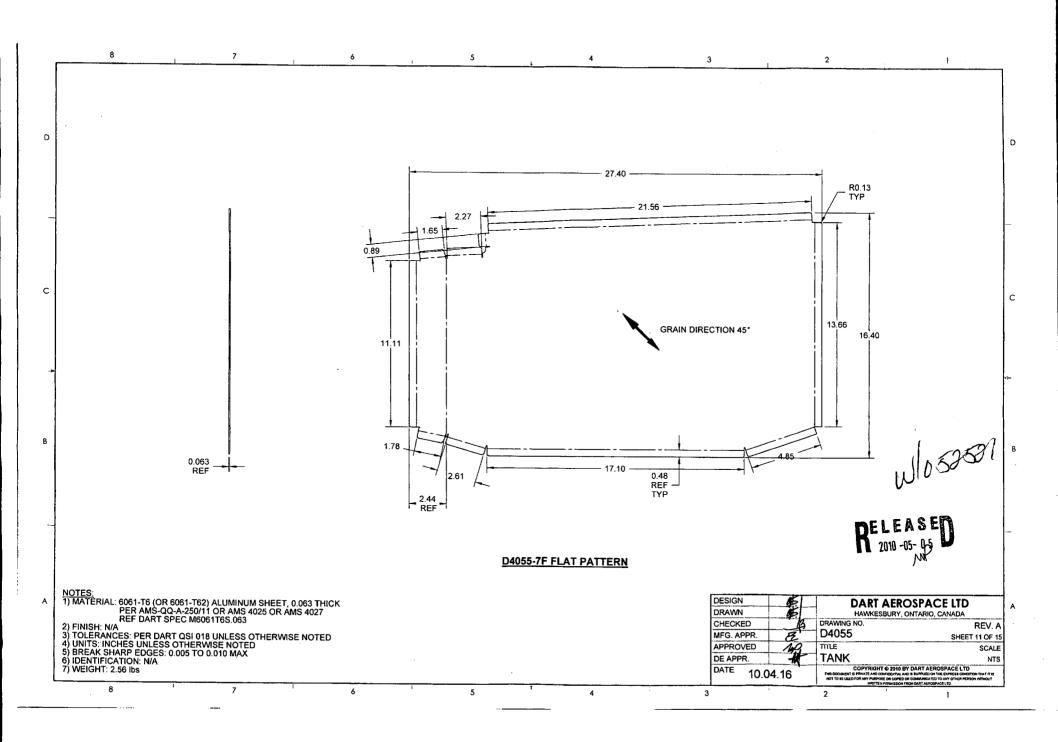


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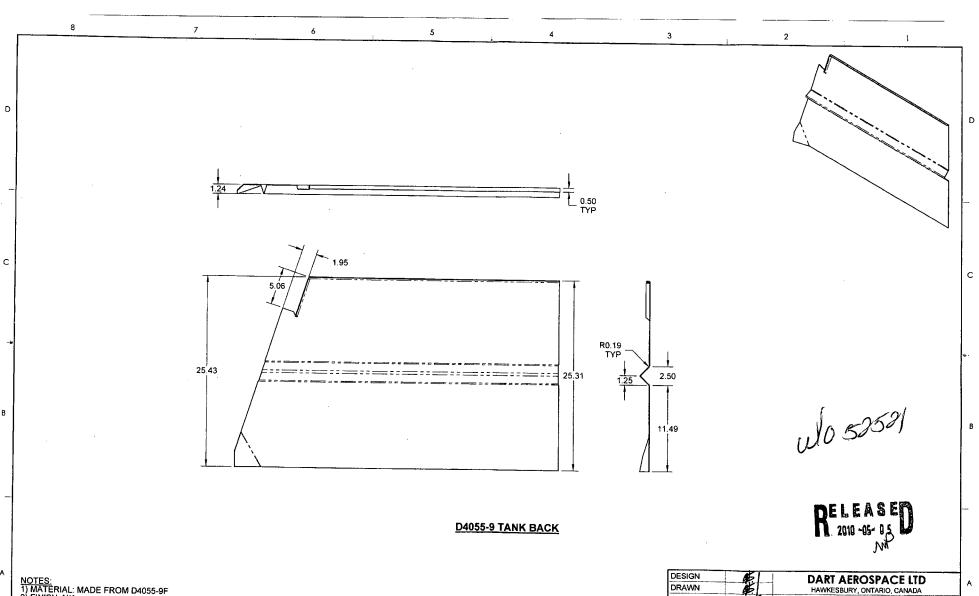


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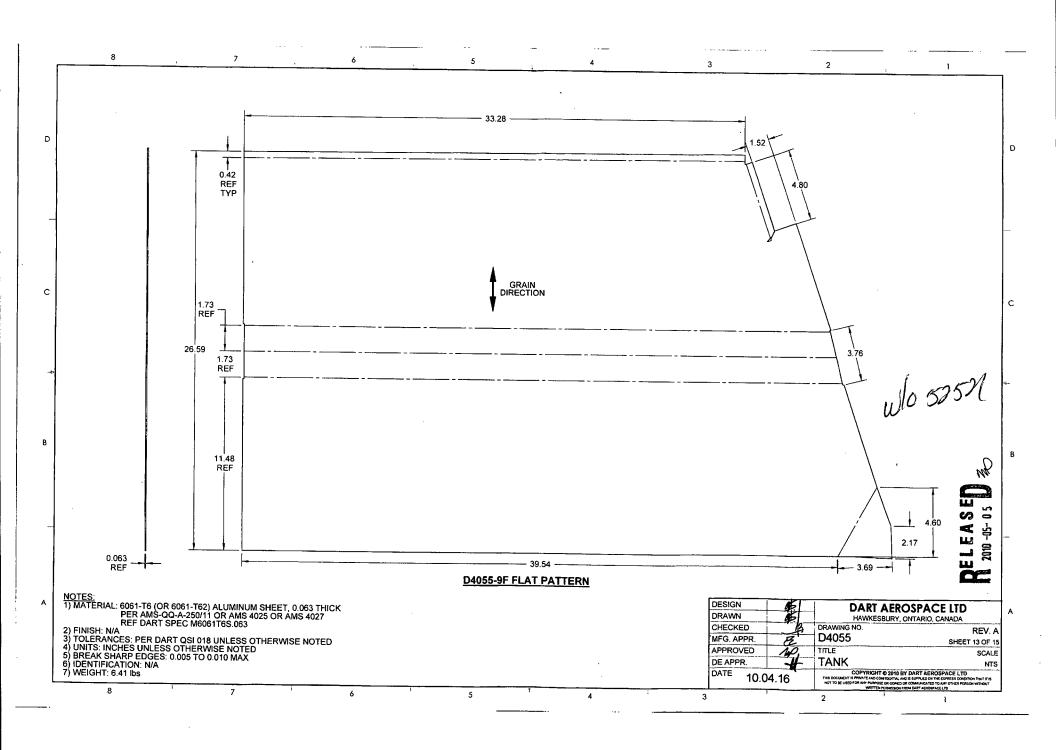
NOTES:
1) MATERIAL: MADE FROM D4055-9F
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 6.41 lbs

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. A D4055 MFG. APPR. SHEET 12 OF 15 APPROVED TITLE SCALE DE APPR. TANK NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD
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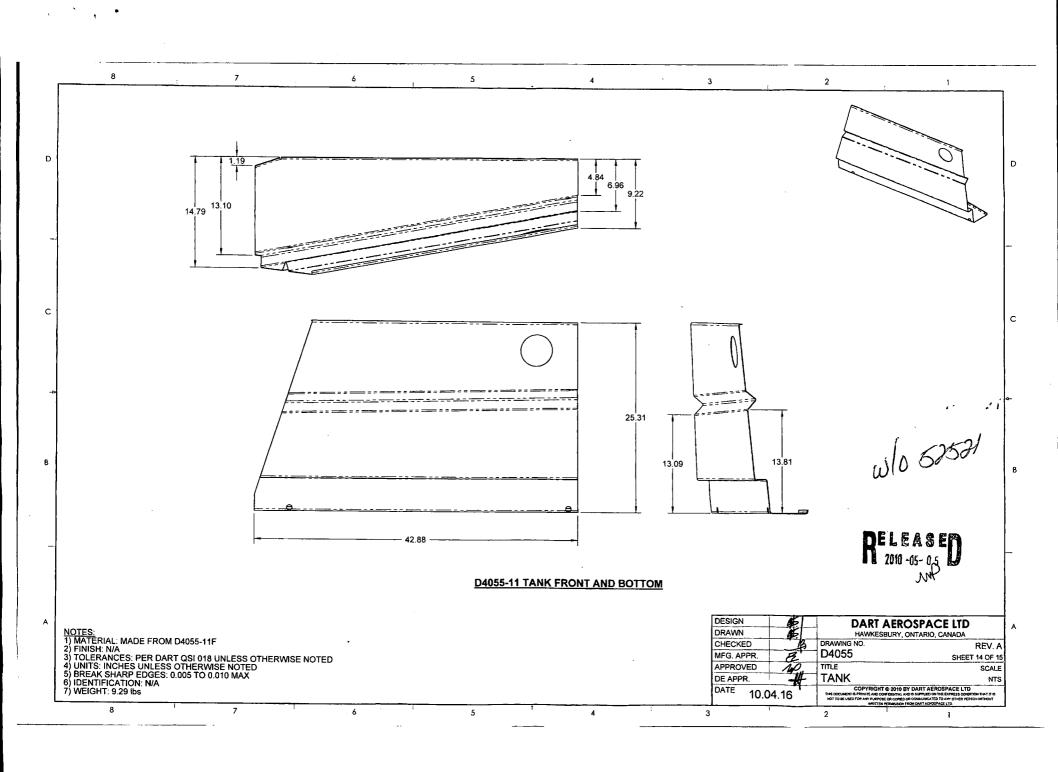
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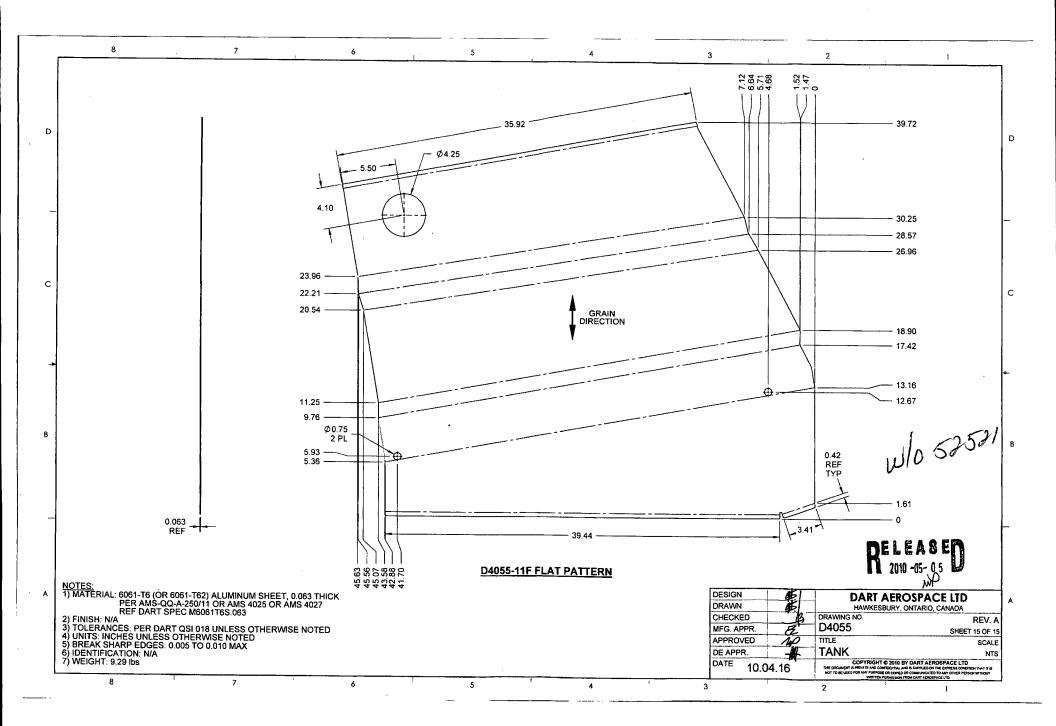


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